

Work Order ID 130823

March-26-15 1:22:32 PM

130823

Page 1

Item ID: D3536-25 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gasket Center
Start Date: 3/26/15 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/26/15 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 1503-27 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3536	Rev A

100 FLOW WATER JET 0.00
100
Waterjet Memo 0.00 12 0 Jm15-3-28
FLOW CNC Waterjet 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Debur if necessary
ne060 .063

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.00 12 0 Jm15-3-28
Quality Control

120 QC8- Inspect parts - second check 0.00
120
QC Memo 0.00 (13) DAS
Quality Control 38
9-89
APR 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP-00</u>	0.00							
130									
Packaging	Memo	0.00				<u>r13</u>	<u>d</u>	<u>21</u>	<u>15/04/05</u>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				<u>ML5</u>	<u>15</u>	<u>0407</u>	
Quality Control									



DQA: _____ Date: _____



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Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

March-26-15 1:22:32 PM

Page 1

Work Order ID: 130823

130823

Parent Item: D3536-25

D3536-25

Parent Item Name: Gasket Center

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	38.1359	0.5956	7.941334			
										**	(8)	Jm 15.3.28	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT052	38.1359						
						M130840	38.1359		<u>130840.</u>				

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	130823
Description: Gasket		Part Number:	D3536-25
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80"	-		T	Jones
16.35	+/-0.030	16.35"	-		T	
10.90	+/-0.030	10.90"	-		V	Jones
5.45	+/-0.030	5.45"	-		V	
6.00	+/-0.030	6.00"	-		V	
6.75	+/-0.030	6.75"	-		V	
12.75	+/-0.030	12.75"	-		T	
1.89	+/-0.030	1.89"	-		V	
0.30	+/-0.030	0.30"	-		V	
0.30	+/-0.030	0.30"	-		V	
Ø0.19	+0.005/-0.001	0.19"	-		V	

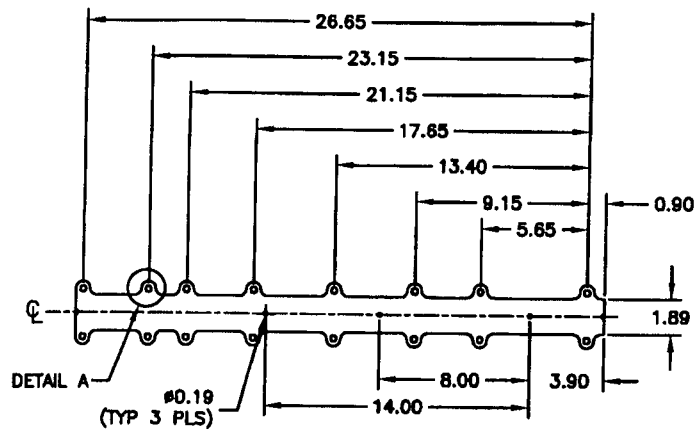
Measured by: Jm	Audited by: DAS 38	Prototype Approval: N/A
Date: 15-3-28	Date: 15-3-28	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

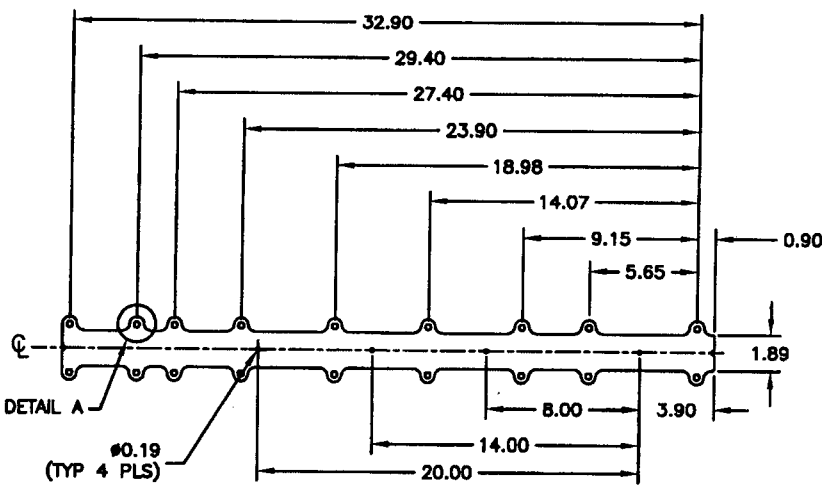
DART

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09.02.12

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
NO. 130823 MVS
1503-27



D3536-11 GASKET



D3536-13 GASKET

NOTES

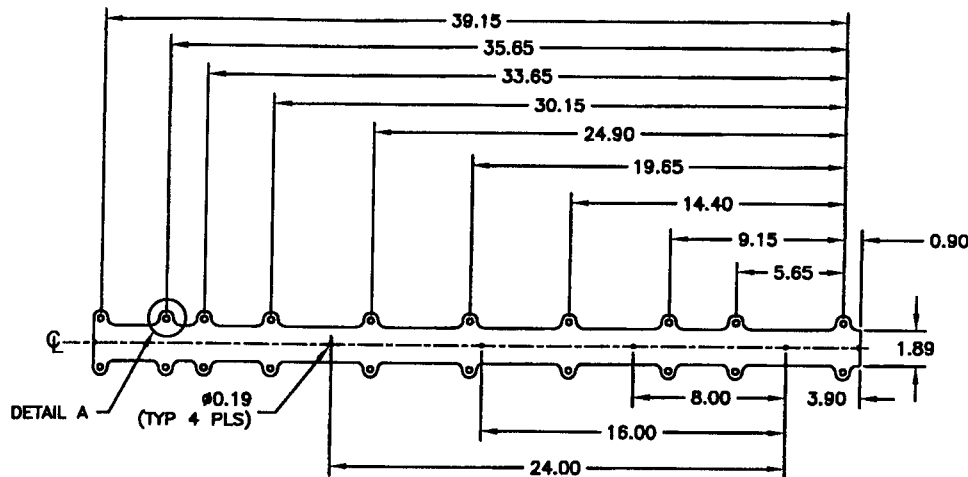
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 1 OF 6
A	06.10.25	SCALE
	NEW ISSUE	1:10

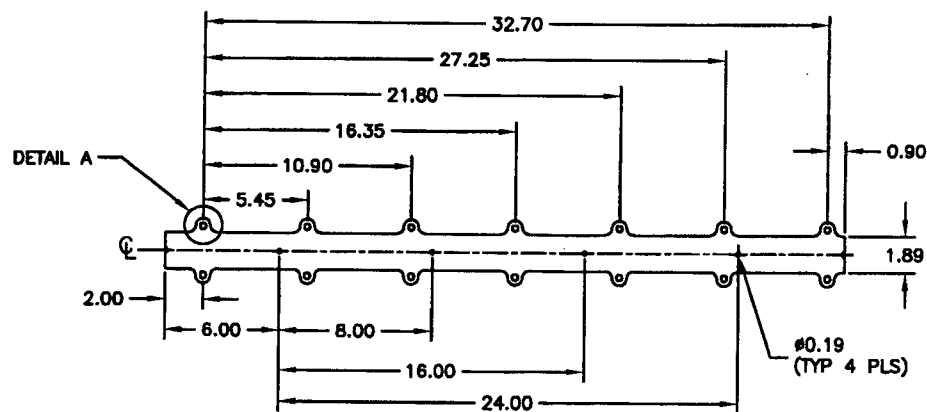
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 2 OF 6
				SCALE 1:10

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070212



D3536-15 GASKET



D3536-21 GASKET

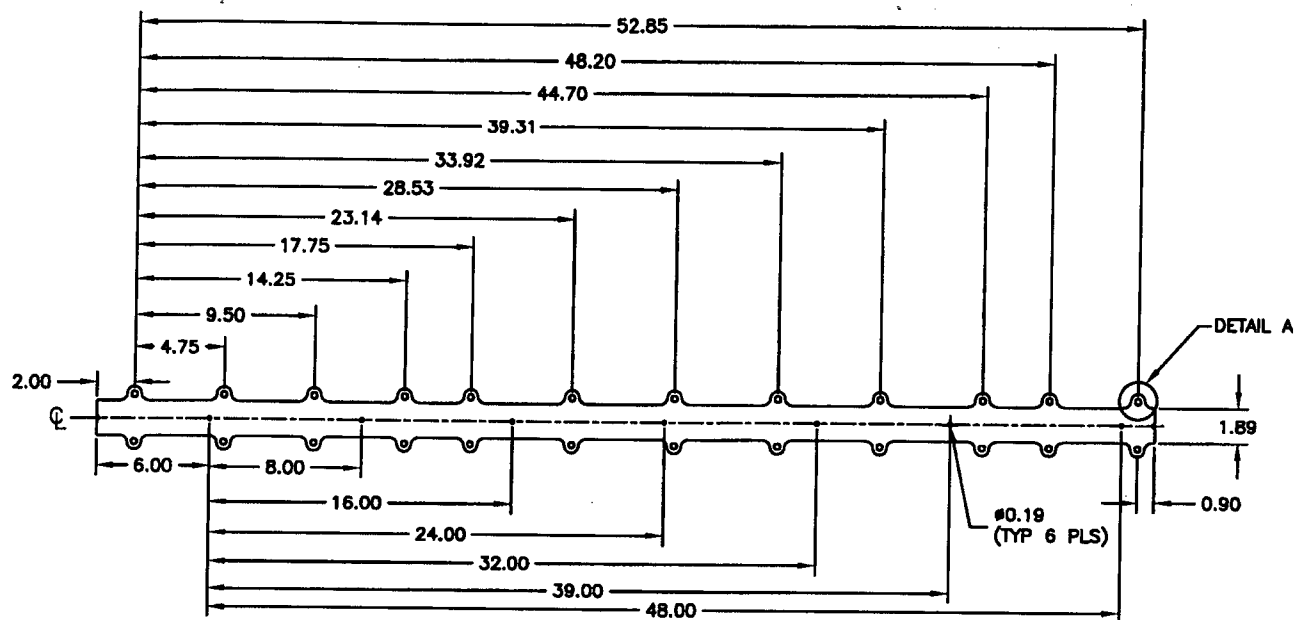
NOTES

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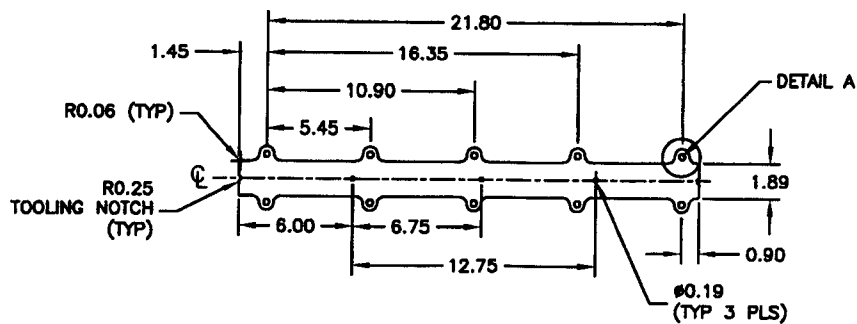
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 3 OF 6
				SCALE 1:10

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07.02.12



D3536-23 GASKET



D3536-25 GASKET

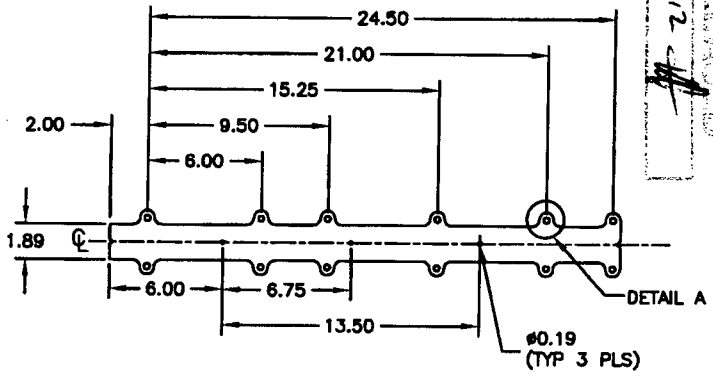
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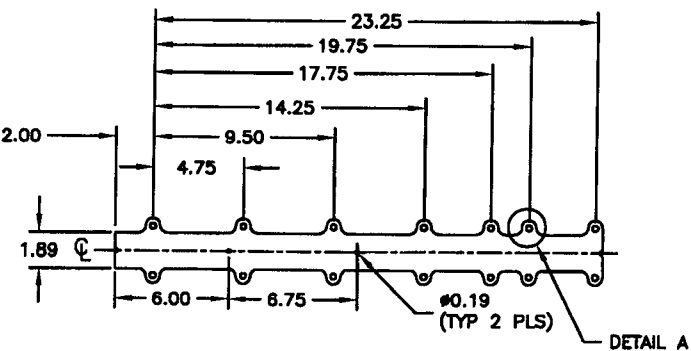
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			GASKET	SHEET 4 OF 6
				SCALE
				1:10

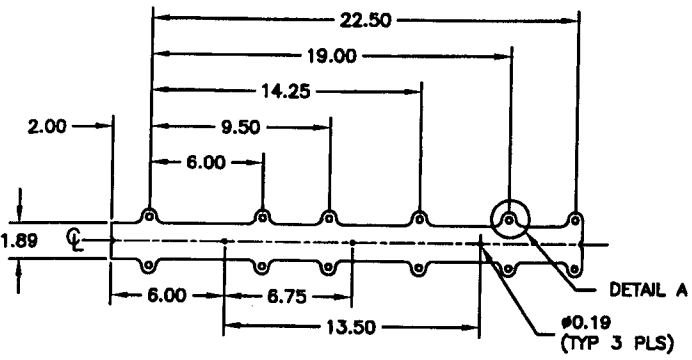
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

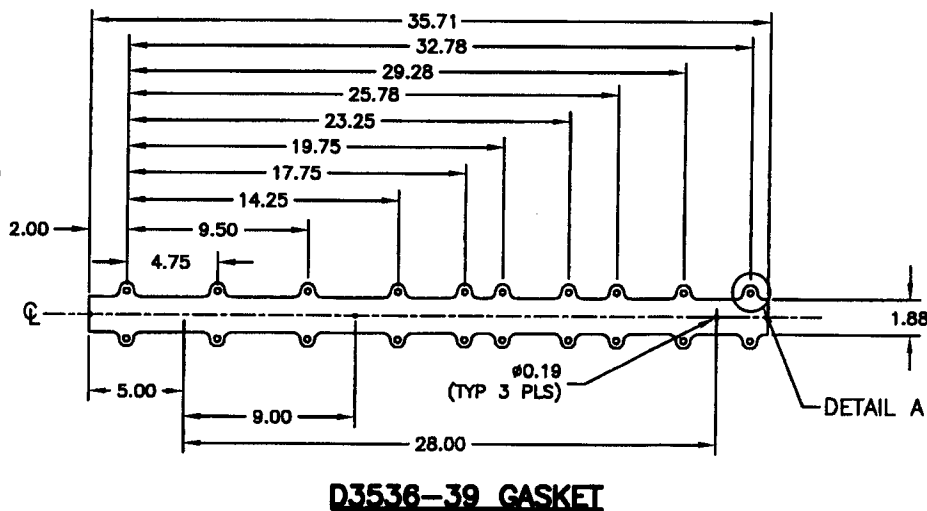
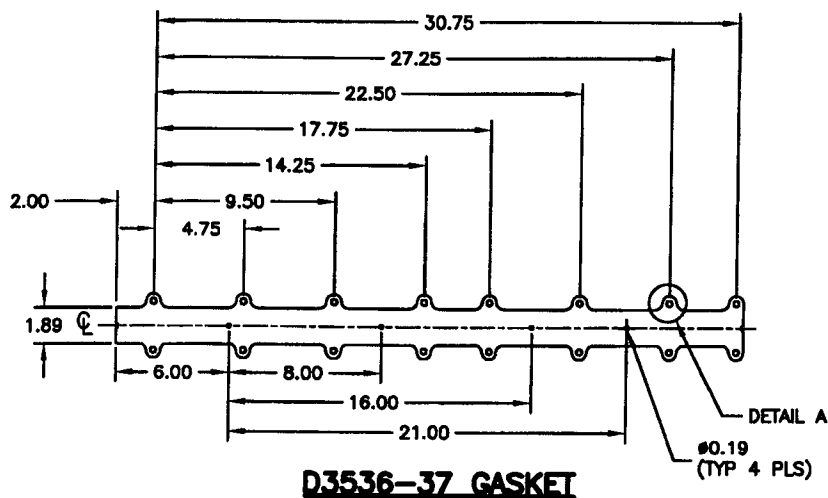
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10

07.02.12
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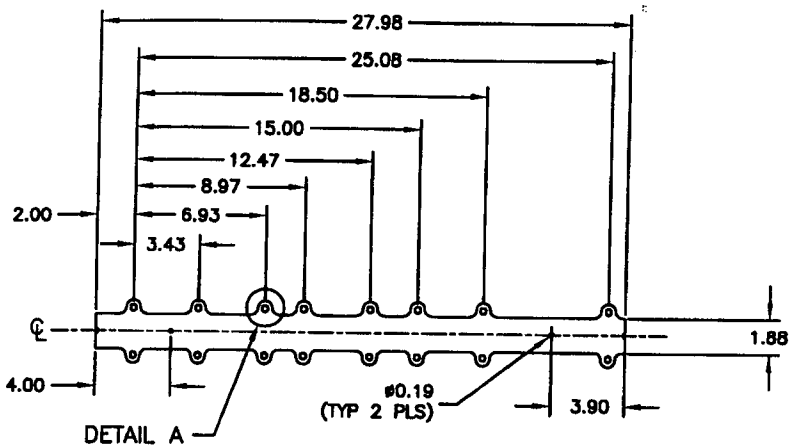
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DART

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CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
AM	<i>[Signature]</i>	D3536	SHEET 6 OF 6
DATE	TITLE		SCALE
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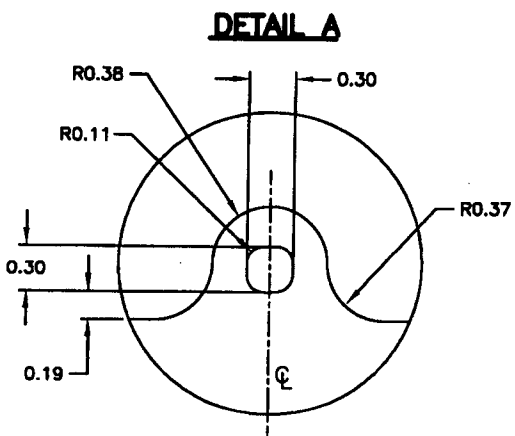
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D3536-41 GASKET

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